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TITLE: METHOD AND EQUIPMENT FOR CONVEYING SURFACE SHEET

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ABSTRACT:

PURPOSE: To prevent the cracking of the front end of a surface sheet for ornamental plywood and the curving of the central part of the sheet, by using a lower suction chamber to suck the sheet toward a lower conveyor in such a manner as to move the range of the suction of the sheet oppositely to the direction of the its conveyance, when dropping the sheet from an upper conveyor onto the lower one.

CONSTITUTION: A surface sheet 1 having a wooden pattern in the longitudinal direction is conveyed in said direction to a plate over a lower conveyor 3 while the sheet is sucked on the bottom of an upper conveyor 2. The suction by an upper suction chamber 11 is stopped when the sheet 1 is located over the lower conveyor 3. The sheet 1 is then dropped onto the lower conveyor 3. At that time, shutters 8 installed in the lower conveyor 3 are moved to sequentially open the suction ports 6 of a lower suction chamber 7 in the direction of the movement of the upper conveyor 2 to suck the dropped sheet 1 by the lower suction chamber in such a manner as to move the range of the suction of the sheet forwards. As a result, the sheet 1 is braked at its non-end part first and the front end of the sheet moves due to inertia in the direction of the conveyance by the upper conveyor 2 so that the surface sheet does not curve.

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